

Work Order ID 68410

Tuesday, April 12, 2011 3:39:39 PM



PRELIMINARY ISSUE

Page 1

Item ID: D4371-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bar

Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:



Reference:

Approvals:

Process Plan:

[Signature]

Date: 11/04/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4371

PA1

100

0.00



Cold Saw

Memo

0.00

Hyd Mech

~~Cut blanks at 52.00"~~

cut blank at 52.2

[Signature]

11/04/27

①

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per photo FB047 & dwg D4371,

FOLIO REV: _____

DWG REV: _____

2-Deburr as required

Manual Mill

[Signature]

11/04/28

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68410

Tuesday, April 12, 2011 3:39:40 PM



Page 2

Item ID: D4371-3

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Setup Start



Revision ID: PRELIM

Stop



Item Name: Bar

Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/04/28

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11/04/28

1

140

0.00



Small Fab

Memo

0.00

Small Fab

Grind off chamfer on fwd end of bar as per dwg

11/04/28

W/O:		WORK ORDER CHANGES						
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Setup Start



Revision ID: PRELIM

Stop



Item Name: Bar

Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00 - inspect to PA1



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: W/A

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

RJ2382

MF
11-05-03

POSITIVE RECALL

EFFECTIVE 11-04-13 AUTH U

RELEASED _____ DATE

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Page 1

Tuesday, April 12, 2011 3:39:46 PM

Work Order ID: 68410



Parent Item: D4371-3



Parent Item Name: Bar



Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.04.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500 		Purchased	No			100	f	269.5000	4.3333	4.561368			
304 BAR .250 x .500													

Location

Loc Qty

Loc Code

MAT006

78

116148

78

MAT050

191.5

117176

191.5

4.4

 4/12/28

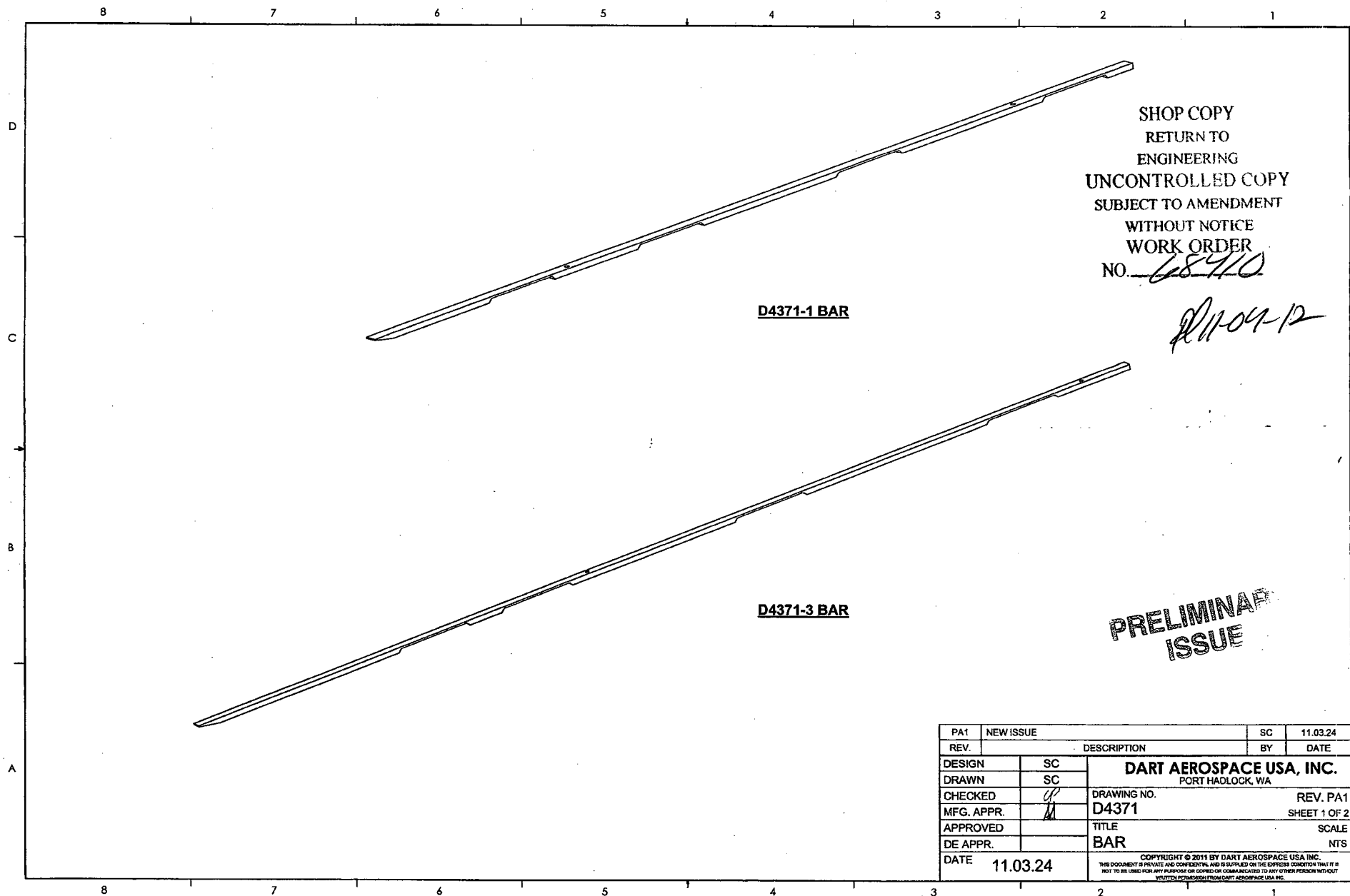
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 68410

11-04-12

**PRELIMINARY
 ISSUE**

PA1	NEW ISSUE	SC	11.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	<i>UP</i>	DRAWING NO. D4371	REV. PA1 SHEET 1 OF 2
MFG. APPR.	<i>MA</i>	TITLE BAR	SCALE NTS
APPROVED		COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DE APPR.			
DATE	11.03.24		

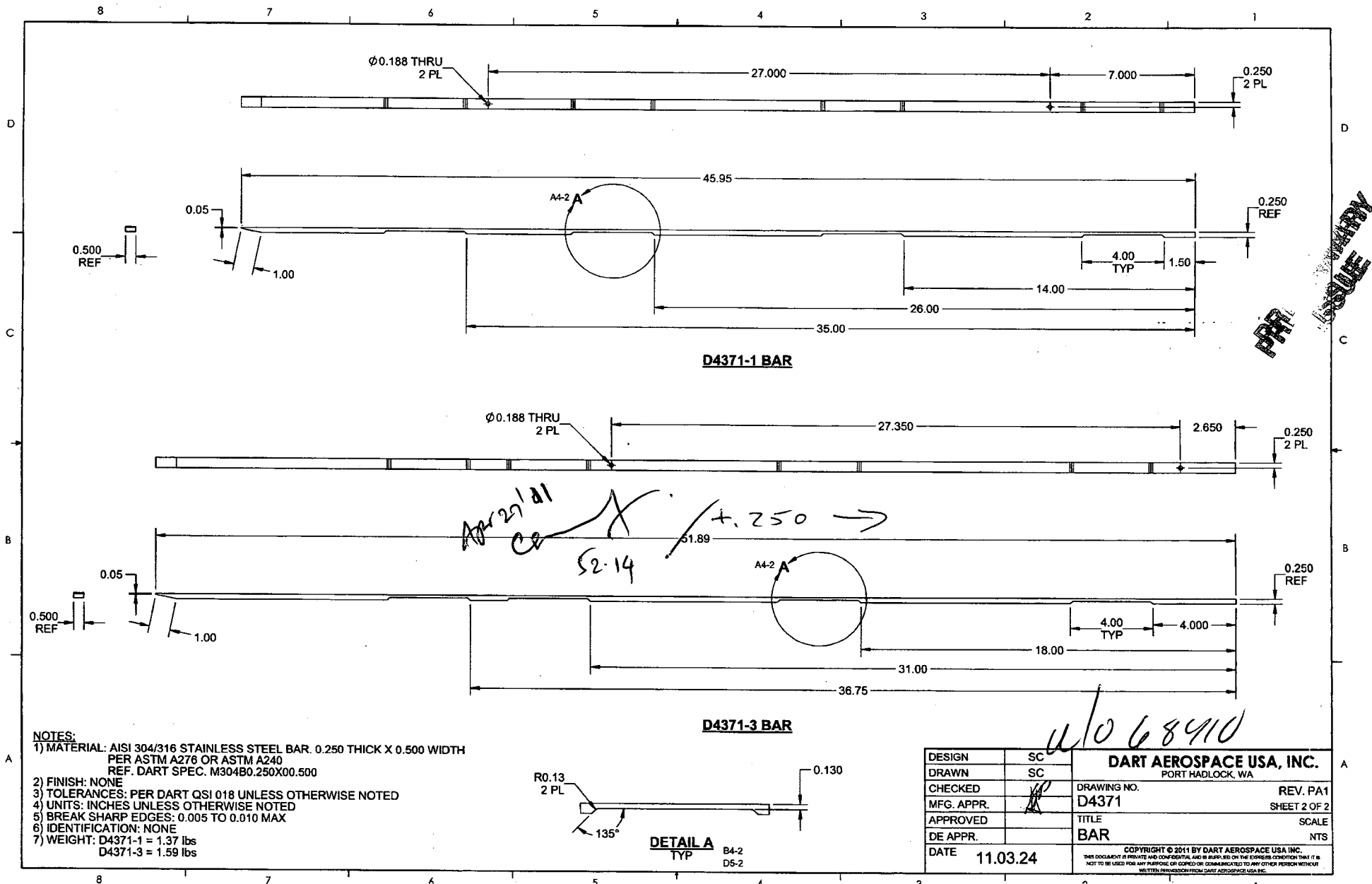
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